

Date: Tuesday, 7/11/2006 1:39:58 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BASKET BASE ASSEMBLY
<b>Job Number</b> :	27858B		
<b>Estimate Number</b> :	10852		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D3324041
<b>This Issue</b> :	7/11/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3324 UNDER REVIEW <sup>PH</sup> 06-07-11
<b>First Issue</b> :	7/11/2006	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	24357B	<b>Drawing Revision</b> :	B
<b>Written By</b> :	<b>Material</b> :		N/A
<b>Checked &amp; Approved By</b> :	<b>Due Date</b> :		8/10/2006
<b>Comment</b> :	<b>Qty:</b>		1 Um: Each

Comment: See Comment Below  
06-07-11  
 : Est Rev: A 05.02.09 New issue KJ/JLM

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D33283	Basket Hinge
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3328-3

Hinge Plate

B23727

PD

06-07-25

2.0	D33481	Clevis
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3348-1

Clevis

B23861

PD

06-07-25

3.0	D33493	Spacer Bushing
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3349-3

Spacer Bushing

B23753

PD

06-07-25

4.0	D33671	Mounting Bracket
-----	--------	------------------



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3367-1

Mounting Bracket

B23862

PD

06-07-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 7/11/2006 1:39:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 27858B

Part Number: D3324041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M4130NTS0500W035

4130 Square tube .5 x .5



Comment: Qty.: 48.9300 f(s)/Unit Total: 48.9300 f(s)  
Material: 4130 Cond. N Square tube per MIL-T-6736,  
1/2" x 0.035" wall  
M4130N-TS0.500W.035)

17679

PD

06-08-02

①

6.0

M569EX05018F

569 Expanded Metal



Comment: Qty.: 28.0000 sf(s)/Unit Total: 28.0000 sf(s)  
Pick:

Qty Part Number Description

Batch

28s M569EX0.50-18F 1/2"-18gauge(.040") carbon steel

M101728

PD

06-08-02

①

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut tubes as per Dwg D3324

Qty Part Number Description

Batch

3 D3324-1 Bottom Tube

4 D3324-3 Full Length Tube

2 D3324-5 Top End Tube

2 D3324-7 Bottom End Tube

10 D3324-9 Vertical Tube

Identify parts appropriately

17679

2-Remove all markings from material & check for foreign objects

3-Drill and Weld as per Dwg D3324 & QSI 004 using DT8781 A & B

4130 rod

4-Deburr as required

PD

8.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

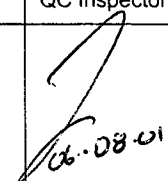
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
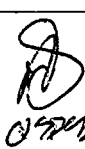
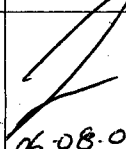
①


POSITIVE RECALL

EFFECTIVE 06-08-01 AUTH: [Signature]

RELEASED [Signature] DATE 06-08-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06-08-01	6	Waiting upon dist'l certs					 06-08-01

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-09	7.0	Inside corners on the bottom of the frame were not welded. Humpner rev.		- Remove powder coat in corners - weld inside of all 4 corners AS per Dwg. QS1004 - Re-powder coat AS per QS1004 - QC 519	 06-08-09 06-08-15 06-08-09 06-08-09		 06-08-09	 06-08-09

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06/08/17

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 7/11/2006 1:39:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 27858B

Part Number: D3324041

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

5C 06/08/03  
PL

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

u-08-16

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

N/A

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/17

Job Completion



u 06-08-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

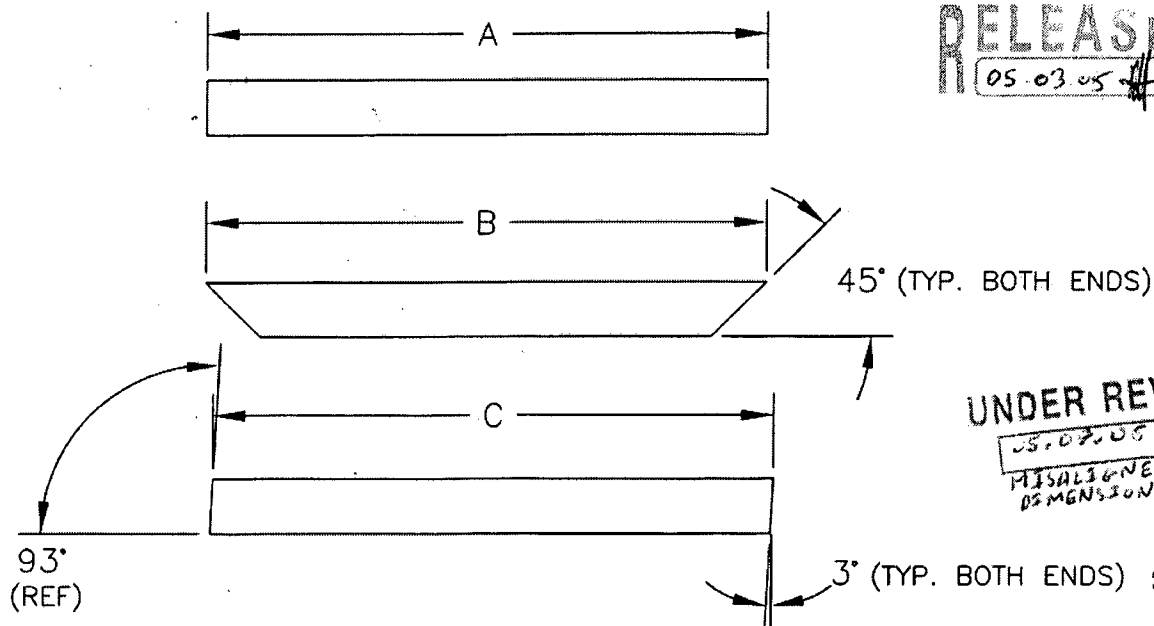
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

DESIGN PH	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3324	REV. B SHEET 1 OF 3
DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE NTS
A	04.10.20	NEW ISSUE	
B	05.03.04	UPDATE MESH MATERIAL SPEC	

**PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY**

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	MOUNTING BRACKET

**RELEASED**  
05.03.05 PH**UNDER REVIEW**  
05.07.05 PH  
MISALIGNED  
DIMENSION P62

D3324-1/-3/-5/-7/-9

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

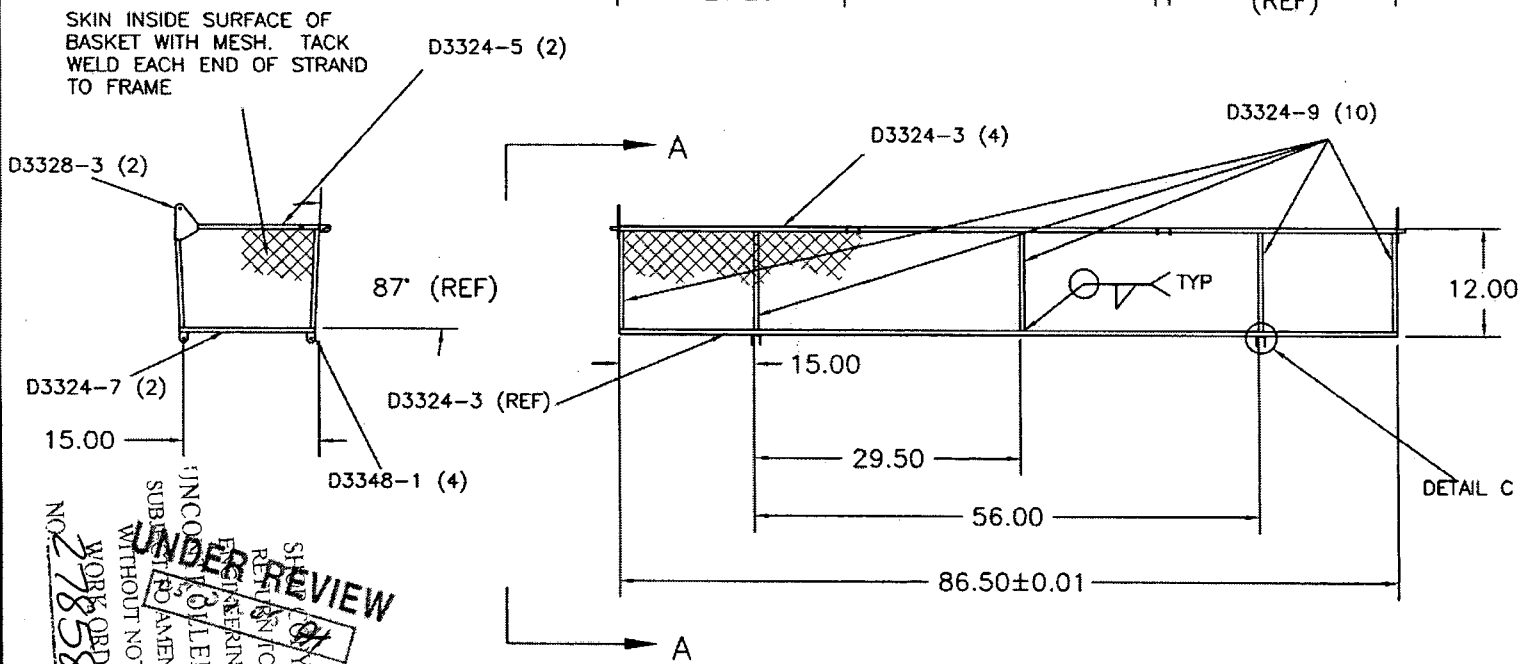
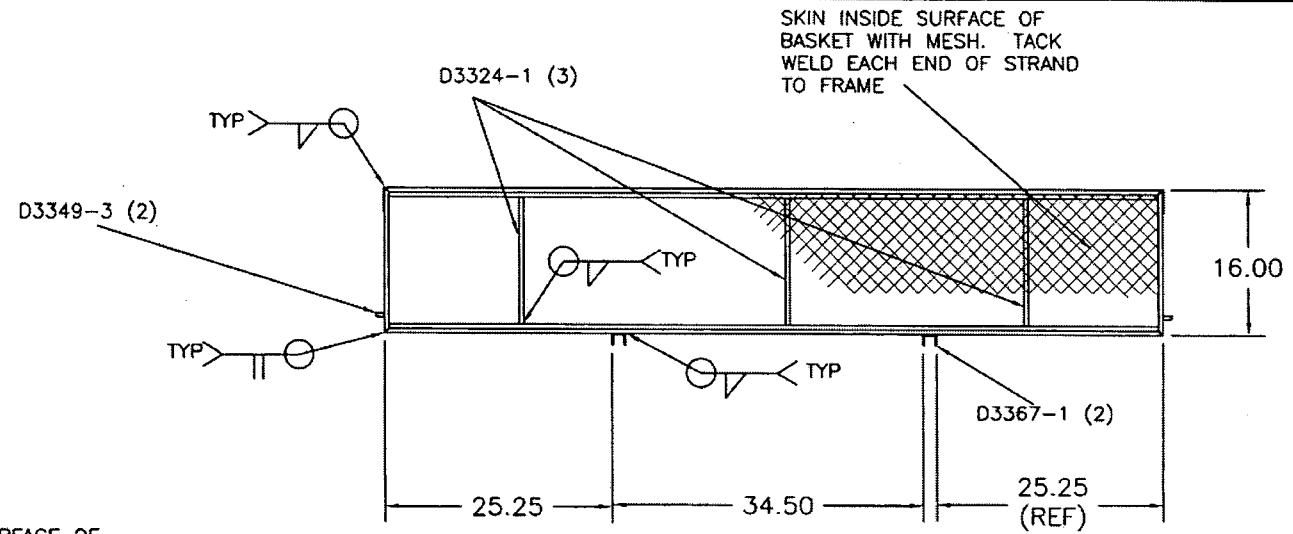
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CHECKED	HH	APPROVED	HH	HAWKESBURY, ONTARIO, CANADA
DATE	05.03.04	DRAWING NO.	D3324	REV. B
		TITLE	BASKET BASE ASSEMBLY	SHEET 2 OF 3
		SCALE	1:20	



**D3324-041 BASKET BASE ASSEMBLY**

- 1) MESH MATERIAL: 1/2" - 18F GAUGE FLATTENED (0.040 THICK) EXPANDED CARBON STEEL (REF. DART SPEC. M569EX0.50-18F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 4.0 UNLESS OTHERWISE NOTED

RELEASED  
05.03.05

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NO WORK ORDER  
278588B

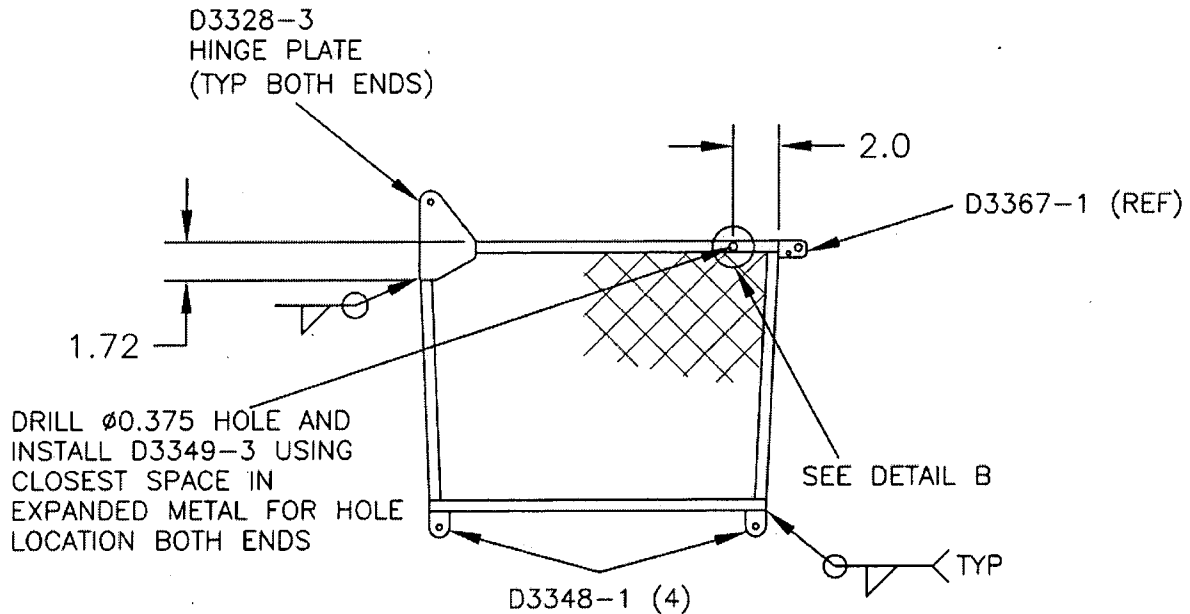
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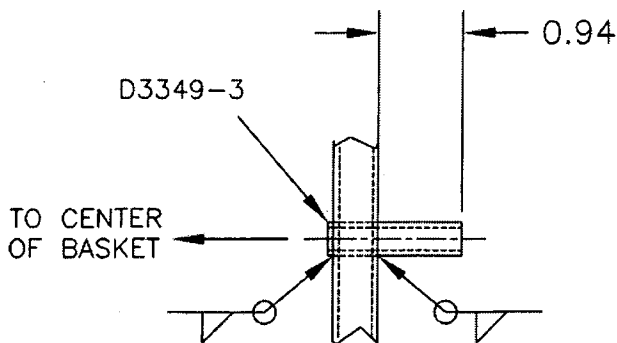
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DATE 05.03.04		TITLE BASKET BASE ASSEMBLY	SCALE 1:8

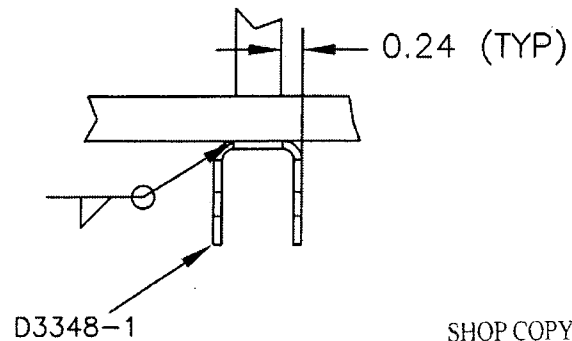


VIEW A-A

RELEASED  
05.03.05



DETAIL B  
(SCALE 1:2)



DETAIL C  
(SCALE 1:2)

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05.07.06 PH

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